



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D412-698-012
Job Sheet 181852



Part No: D412-698-012

Job Qty: 1 ea

Part Name: Cabin Door Roller RH Aluminum Door



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN-D412-698 REV.G IPP Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3
KJ/DS IPP Rev:D 08-01-28 change to rev D ECN 1104 DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Stores/Pkg-2	9-89	AUG 16 2018
110	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging1-4	9-89	AUG 30 2018
120	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC4	9-89	AUG 31 2018
130	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-2	9-89	AUG 31 2018
135	DC	1 pcs	8/31/18	8/31/18	0.00	0.00	DC	9-89	AUG 31 2018
140	QC21-FG	1 Ea	8/31/18	8/31/18	0.00	0.00	QC21	9-89	AUG 31 2018

Part Op 130 - Identify and pack for shipping as per PPP D412-698-012 Location : FG034
Descriptions: 135 - Photocopy bluefile and create labels per PPP D412-698-012 CHG003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3121-141	Bracket Assembly	3 Ea (3 ea)	90-Start up Operation	5093152
D3121-144	Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5104620
D3137-043	Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5068722
D3183-044	Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5091586
D3199-1	Bracket	9 Ea (9 ea)	90-Start up Operation	5093154 x 8
D3202-1	Cover	1 Ea (1 ea)	90-Start up Operation	5063076 x 1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3121-141	3	4	0
	D3121-144	1	0	0
	D3137-043	1	6	0
	D3183-044	1	1	0
	D3199-1	9	110	0
	D3202-1	1	21	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Description \	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; text-align: center;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Dart Aerospace Ltd. 1270 Aberdeen Street Hewesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S102951 Part: D412 - 698 - 012 Job No: 181852 Serial No/Batch: S102951 Revision: G Inspector: Exp Date: Instructions: TC STC SH92 - 43 Issue 5 Ref AA STC SR01446NY 08/02/08, EASA S				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																
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6.0 PARTS LIST – CABIN DOOR MODIFICATION KITS
(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Qty -027	Qty -028	Part Number	Description
X								D412-698-011	CABIN DOOR ROLLER KIT, LH
	X							D412-698-012	CABIN DOOR ROLLER KIT, RH
		X						D412-698-013	DOOR HANDLE KIT
			X					D412-698-017	REPLACEMENT DOOR TRACK KIT
				X				D412-698-019	BEARING OVERHAUL KIT
					X			D412-698-021	REPLACEMENT SHIM KIT
						X		D412-689-027	BRACKET KIT, LH (ALUMINUM DOORS)
							X	D412-689-028	BRACKET KIT, RH (ALUMINUM DOORS)
3	3							D3121-141	BRACKET ASSEMBLY
1								D3121-143	BRACKET ASSEMBLY
	1							D3121-144	BRACKET ASSEMBLY
1	1							D3137-043	BRACKET ASSEMBLY
1								D3183-043	BRACKET ASSEMBLY
	1							D3183-044	BRACKET ASSEMBLY
9	9		9					D3199-1	BRACKET
						1		D3199-3	FORWARD BRACKET, LH
							1	D3199-4	FORWARD BRACKET, RH
1	1		1					D3202-1	COVER
		4						D3203-1	HANDLE
		1						D3220-041	DOUBLER
		1						D3220-042	DOUBLER
		2						D3220-3	DOUBLER
				7				D3121-21	BOLT
				5				D3121-241	BEARING ASSEMBLY
				1				D3137-3	GUIDE
				1				D3137-5	WASHER
				2				D3183-045	BEARING ASSEMBLY
					3			D3238-1	SHIM
					1			D3238-3	SHIM
					2			D3238-5	SHIM
					6			D3238-11	SHIM
					2			D3238-13	SHIM
					4			D3238-15	SHIM
		8						NAS1149D0463J	WASHER (AN960JD416L)
		8						MS21042L4	NUT (OR MS21042-4)
		16						MS24694-S98	SCREW
				1				MS24694-S101	SCREW

REFERENCE ONLY

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Revision: **G**

Date: 17.11.23

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